

Work Order ID 131222

March-31-15 7:24:11 AM

shp April 7

131222

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Item ID: D4964-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mid Step Leg Assembly
 Start Date: 3/31/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/06/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4964	A								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D4964								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

APR 02 2015

120	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
120									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:10 OVEN TEMPERATURE: 320° FINISH TIME: 8:40								

DAS 34 9-89

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							DAS 38 9-00
130									
QC	Memo	0.00							
Quality Control									APR 02 2015
140	Identify as per dwg & Stock Location: _____	0.00							DAS 27 9-00
140									
Packaging	Memo	0.00							
Packaging									APR 02 2015
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

MS-4-2

Picklist Print

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Work Order ID: 131222

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Parent Item: D4964-043

D4964-043

Parent Item Name: Mid Step Leg Assembly

Start Date: 3/31/15

Required Date: 4/06/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.11.05 NEW ISSUE DD VERF:JFS IPP
REV:B 14.01.10 AS PER DWG REV.A DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4964-1 *D4964-1* Step Leg		Manufactured	No				Each	0.0000		2		15/04/02	DAS 36 9-89
D4965-3 *D4965-3* Step Spacer		Manufactured	No				Each	1.0000		1		15/04/02	DAS 36 9-89
Location GA 116187 Loc Qty 1 Loc Code													
D4965-7 *D4965-7* Step Spacer		Manufactured	No				Each	1.0000		2		15/04/02	DAS 36 9-89
Location GA 116188 Loc Qty 1 Loc Code													
MS20470AD4-5 *MS20470AD4-5* RIVET, UNIVERSAL HEAD		Purchased	No				Each	1,890.000		24		15/04/02	DAS 36 9-89
Location GA m128401 m128813 ST310 m128813 Loc Qty 1869 1845 24 21 21 Loc Code													

DAS
36
9-89

M131800
(24)

(24) B131223

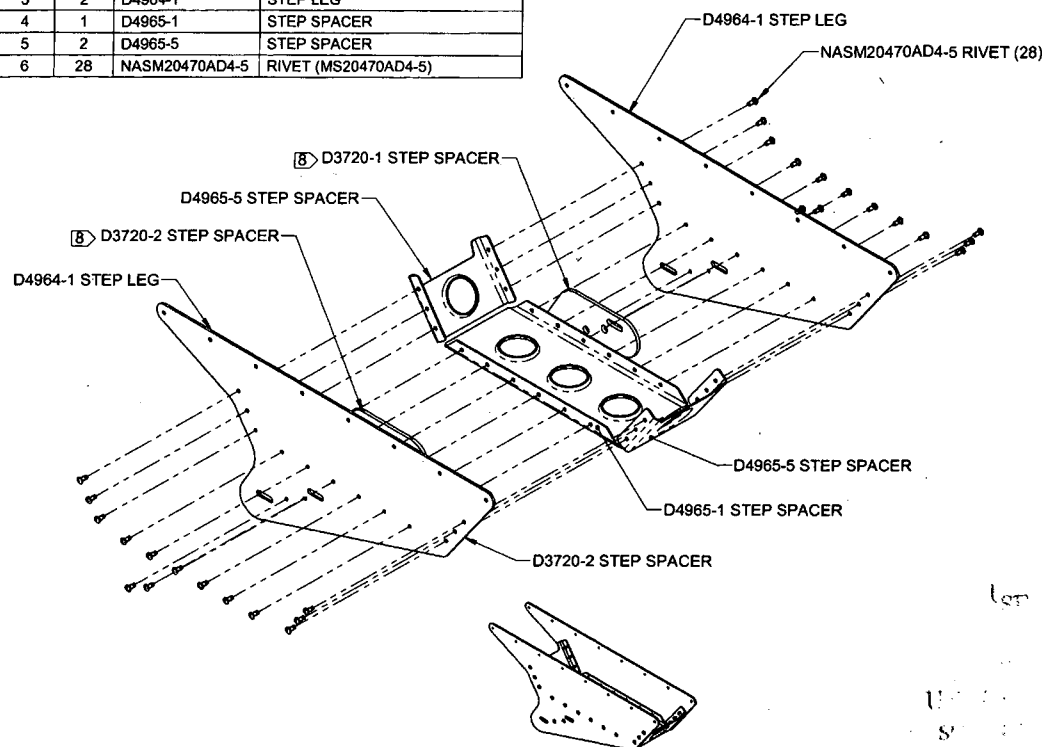
(24)

~~B131223~~ (24)

B131226 (24)

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4964-041	MID STEP LEG ASSY
1	1	D3720-1	STEP SPACER
2	1	D3720-2	STEP SPACER
3	2	D4964-1	STEP LEG
4	1	D4965-1	STEP SPACER
5	2	D4965-5	STEP SPACER
6	28	NASM20470AD4-5	RIVET (MS20470AD4-5)

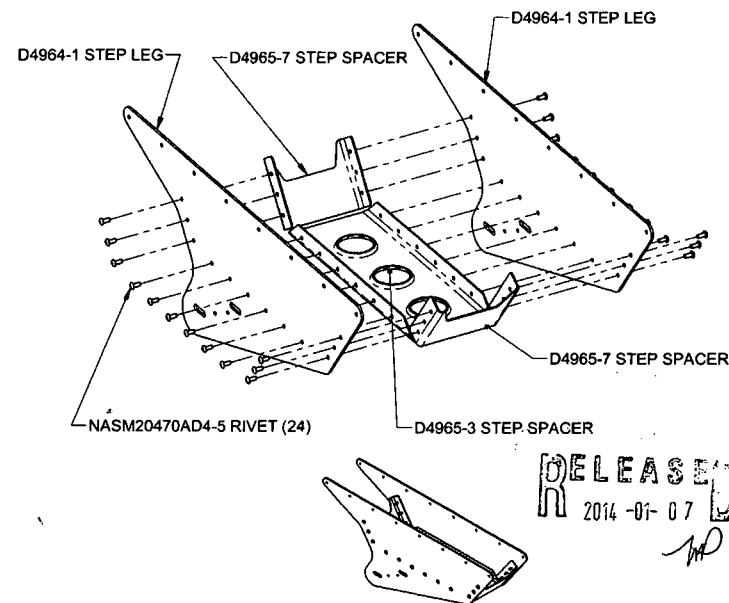
ITEM	QTY -043	P/N	DESCRIPTION
	X	D4964-043	MID STEP LEG ASSY
1	2	D4964-1	STEP LEG
2	1	D4965-3	STEP SPACER
3	2	D4965-7	STEP SPACER
4	24	NASM20470AD4-5	RIVET (MS20470AD4-5)



D4964-041 MID STEP LEG ASSEMBLY
(FOR D350-591-121/-122 STEP MOD KITS)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GLOSS WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4964-041" OR "D4964-043" PER DART QSI 044 6.1
- 7) WEIGHT: 0.44 lbs
- 8) D3720-1/-2 STEP SPACERS MOUNTED WITH COUNTERSUNK HOLES TO THE INSIDE OF ASSEMBLY. GRIND RIVETS FLUSH TO INSIDE SURFACE.

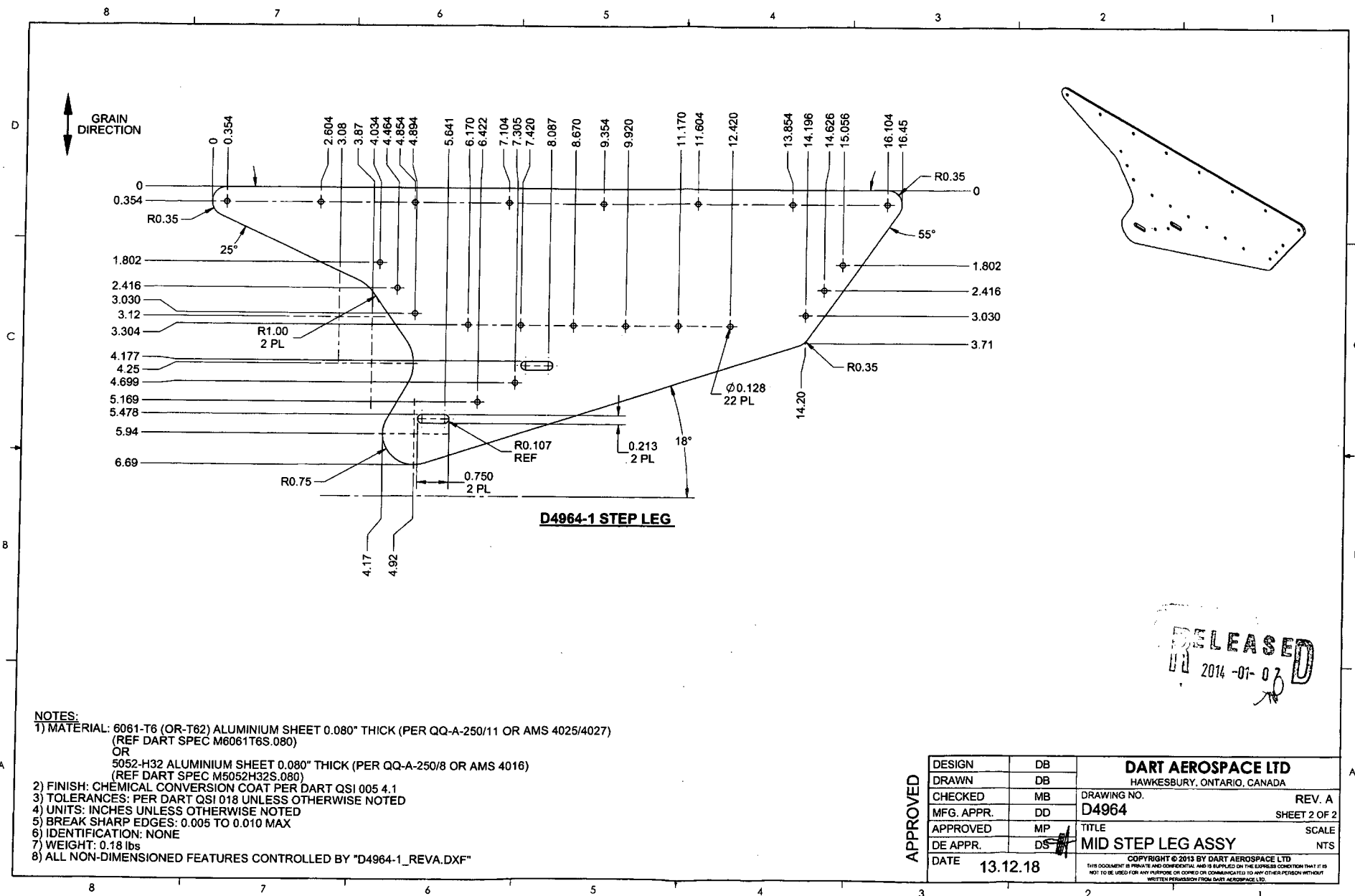


D4964-043 MID STEP LEG ASSEMBLY
(FOR D350-591-213/-214/-311/-312 STEP MOD KITS)

A		NEW ISSUE		DB	13.10.24
REV.		DESCRIPTION		BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	DB			SHEET 1 OF 2	
CHECKED	MB	DRAWING NO.		REV. A	
MFG. APPR.	DD	D4964		SCALE	
APPROVED	MP	TITLE		NTS	
DE APPR.	DS	#		MID STEP LEG ASSY	
DATE	13.12.18	COPYRIGHT © 2013 BY DART AEROSPACE LTD		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

NO 131222
MLJ
15-03-31



RELEASED
2014-01-03